### Work Order ID 63912

Thursday, November 18, 2010 3:55:43 PM



Page 1

Item ID: D4005-041 Accept Setup Start **Revision ID:** Stop Fwd Floor Gutter Item Name: **Start Date:** 11/19/2010 Start Qty: 4.00 **Cust Item ID: Required Date: 12/3/2010** Req'd Qty: 4.00 **Customer:** Reference: Process Plan: Start Run Date: 10-11-19 Approvals: Tooling: Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Reject Tool # Plan Accept Reject Insp. Work Center ID Description Code Qty Qty **Run Hours** Number Stamp **Draw Nbr Revision Nbr** D4005 Α 100 0.00 B10-11-29 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg (D4005-13) Dwg Rev: 6061.040 Prog Rev: 2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B10-11- 29

**Quality Control** 

Dart Ae	rospace	e Ltd						
W/O:			WO	RK ORDER CHANGE	S			
DATE	STEP	PRO	PROCEDURE CHANGE				Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cated	iorv:	NCR: Yes	No DQA:	Date:	
		esolution:						
NCR:		\	WORK ORDE	R NON-CONFORMA	NCE (NCR	3)		
D.4.T.F	0.755	Description of NC		Corrective Action Section		Verification	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

### Work Order ID 63912

Thursday, November 18, 2010 3:55:43 PM



Page 2

Item ID:

D4005-041

Accept



Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name:

Fwd Floor Gutter

11/19/2010

Start Qty: 4.00

Required Date: 12/3/2010

**Reg'd Oty:** 4.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N): Date:

Date:

Run

Start

Stop



**Work Center ID** 

Sequence ID/

Operation

OC

Quality Control

Description

QC8- Inspect parts - second check

Memo

Set Up/

**Run Hours** 

D10/4/30

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

130

120



Brake NC

Bend as per dwg

Memo

Memo

Bend D4005-13 as per Dwg

0.00

0.00 50 10/12/1

140



Quality Control

QC5- Inspect part completeness to step on W/O

W/O:			V	VORK ORDER CHANGES				
DATE	STEP	PROC	EDURE CH	HANGÉ	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				1				
		•						
				# 				
			*				$\mathcal{A}$	
Part No	: <u>D40</u>	05-041 PAR#:	Fault Ca	itegory: Small End NC	R (Yes) N	lo DQA:	Date: _/	10209.
	R	esolution: Accepted	Disposit	tion: Use AS is QA	: N/C Clo	sed:	Date: _	11/02/10
NCR:	3912	Wo	ORK OR	DER NON-CONFORMANCE	(NCR)			
DATE	STEP	Description of NC		Corrective Action Section B		Verification	n Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Section C		QC Inspector
		GTY. 1 CRACKED WHILE	1	TAG PART AND	160		1	
10.12.01	130	BEWDING AT HOLE LOCATO	v. J.	PROCEED WITH CAUTION, THOROUGH WEDERTHAN OF PART AFTER WELDERY SHOUD	10.00.			0
		RC. PROCESS.	60.12.01	THOROUGH WIPECTON OF	( è	winds	ioned	10/12/05
ļ		14. 14000).		NOT ROVERL AWY CRACK.	`	(3(1/2))		10/12/09
1				A ROVERY AWY GOLL.	<u></u>	h		
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#### Work Order ID 63912

Thursday, November 18, 2010 3:55:43 PM



Page 3

Item ID:

D4005-041

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Fwd Floor Gutter

**Start Date:** 

11/19/2010

Start Qty: 4.00

**Required Date: 12/3/2010** 

Req'd Qty: 4.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date:

Tooling:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Run



Stop

Start

Sequence ID/

Work Center ID

141

Large Fab

Large Fab

Operation **Description** 

Weld per dwg A/R Aluminum rod Batch: MIOBUSL 0.00

Memo

Memo

Memo

1- Weld D4003-13 tube to angle as per dwg D4005

Date:\_\_\_\_\_

2- grind flush as per dwg

Tool ID

Tool # Plan Code

Ar 10.12.03 4

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

142

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

0.00

143

Quality Control

QC5- Inspect part completeness to step on W/O

W/O:		WORK ORDER CH	CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector		
				)e, 1					
				-					
	711 -			$\sim$					

Part No: <u>D4005-04</u> PAR #:	Fault Category:	NCR: Yes No DQA:	Date: <u>//บะ/09</u>
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR: 6	3912	\	WORK OR	DER NON-CONFORMANCE	E (NCR)				
		Description of NC		Corrective Action Section B		Verification	Approval	Approval	
DATE	STEP	Section A	Initial Action Description Sign & Chief Eng Date		Sign & Date	Section C	Chief Eng	QC Inspector	
10.02 <i>0</i> 5	H	PIT HOLES IN WELD APTER ARWDING FLUSH, OITY. (2) R.C. GROCESS.	60.10.05 State	ACCEPTABLE ON THE PASIS THAT THE PART 15 NOT STRUCTAL. PURPOSE IS 70 COLLECT	In 12.04	Sulator	10.17.01 051042	्र १०१७कि	
·				FUEL LEAKS.			•		
•									

### Work Order ID 63912

Thursday, November 18, 2010 3:55:43 PM



Page 4

Item ID:

D4005-041

Accept

Setup Start

Stop



**Revision ID:** 

**Item Name:** 

Fwd Floor Gutter

**Start Date:** 

Required Date: 12/3/2010

11/19/2010

Start Qty: 4.00 Req'd Qty: 4.00



**Cust Item ID:** 

**Customer:** 

Reference:

				_	
A	nr	ro	W	ดไ	s:

Process Plan:

QC:

Date:

Date: \_\_\_\_\_

**Tooling:** 

SPC (Y/N):

Set Up/

**Run Hours** 

Date: Date: Run

Start

Stop



Sequence ID/

**Work Center ID** 

150

HandFinish

Operation Description

Chemical Conversion Coat per QSI005 4.1

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Oty

Reject Number

Insp. Stamp

Hand Finishing

Memo

0.00

160

Powdercoat

Powder Coating

Grey Sandtex(Ref: 4.3.5.6) per OSI005 4.3

0.00

0.00

H. Bl 10-12-8

170

QC

QC3- Inspect Part Finish

0.00

10/12/09

Quality Control

Memo

	-									
W/O:		·	W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cat	egory:	NCR:	: Yes 1	lo <b>DQ</b>	<b>A:</b>	Date:	
	R	esolution:	Disposition	on:	QA: I	N/C Clo	sed:		Date:	,,,,,
NCR:			WORK ORE	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC			tion B		Verific	ation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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#### Work Order ID 63912

Required Date: 12/3/2010

Thursday, November 18, 2010 3:55:43 PM



Page 5

Item ID:

D4005-041

Accept

Setup Start



Revision ID:

Item Name: Start Date:

Fwd Floor Gutter

11/19/2010

Start Otv: 4.00

Reg'd Otv: 4.00



**Cust Item ID:** 

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop



Stop

Sequence ID/ Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location 2414

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept Oty

Reject Oty

Run

Reject Number

Insp. Stamp

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

W/O:	•		WC	RK ORDER CHANG	iES					<u> </u>
DATE	STEP	PRO	OCEDURE CHAI	NGE	B	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: \	'es N	o <b>DQ</b> /	<b>4:</b>	Date: _	
	R	esolution:	Disposition	ı:	_ QA: N/	C Clos	sed:		Date: _	
NCR:			WORK ORD	R NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	tion B	gn & Date	<b>Verific</b> Secti		Approval Chief Eng	Approval QC Inspector
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## **Picklist Print**

Thursday, November 18, 2010 3:55:43 PM

Work Order ID: 63912

Parent Item: D4005-041

Parent Item Name: Fwd Floor Gutter



**Start Date:** 11/19/2010

Required Date: 12/3/2010

Start Oty: 4.00

Required Oty: 4.00

Comments:

IPP rev A 10.01.21 new issue Prelim EC verified by:DD

IPP Rev:B

1	10.05.03 as per EC	N10-562 DD ver	ified by	:EC									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4003-13 Fwd Fuel Gutter Line	HARA INI 1884	Manufactured	No			141	Each	1.0000	1    <b>         </b>	4	1 10 · 18	9.03	3
				<u>Location</u> ST	363936 59682	<u>Loc (</u>	<u>Oty</u> 1 1	Loc Code		3	_		
M2024T3S.040  2024-T3 .040 sheet		Purchased	No			100	sf	280.0400	0.42	1.76842		- 79	
				<u>Locatior</u> MAT	<u>1</u>	Loc (	<u>Qty</u> 71.6	Loc Code				(ii	١

Location		Loc Qty	Loc Code	
MAT		71.6		
	114415	71.6		
MAT22		208.44		
	110305	21.93		
	111786	9.66		
	112291	28.25		<u> </u>
	112331	52		
	113162	96.6		113162

W/O:	*		W	ORK ORDER CHANG	GES			
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date:	
	R	esolution:	Dispositio	n:	QA: N/C Cld	sed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR	)		
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DART AEROSPACE LTD	Work Order: 63912 '
Description: FwD Floor Gutter	Part Number: D4005-13
Inspection Dwa: D4005-041, Rev: 14	Page 1 of 1

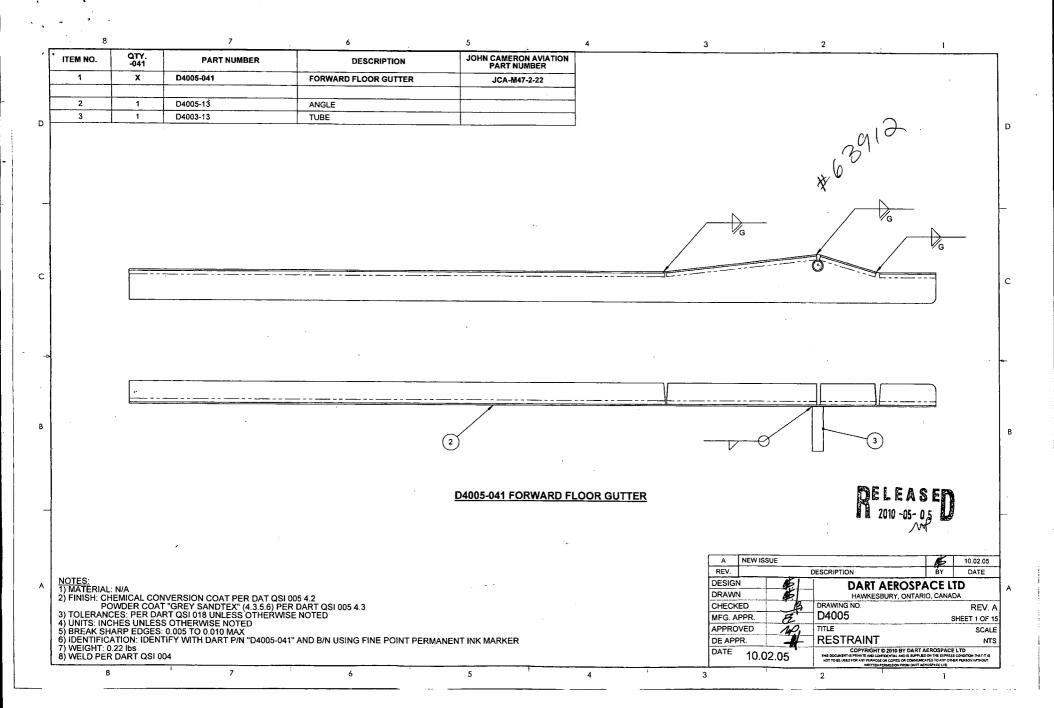
## FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

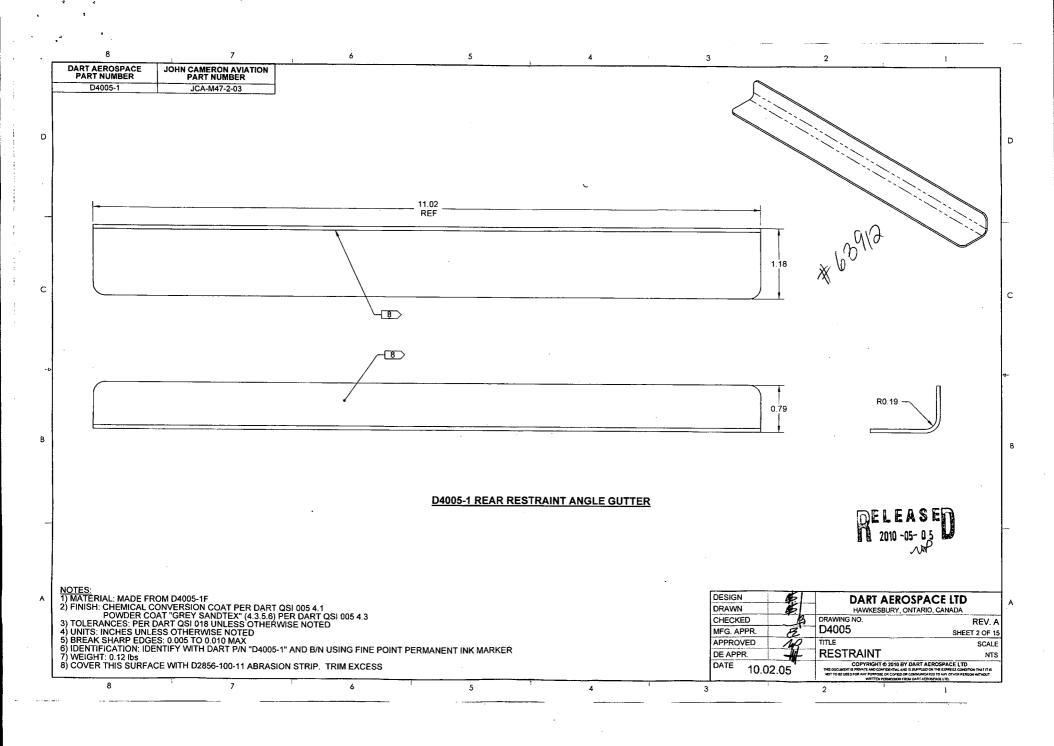
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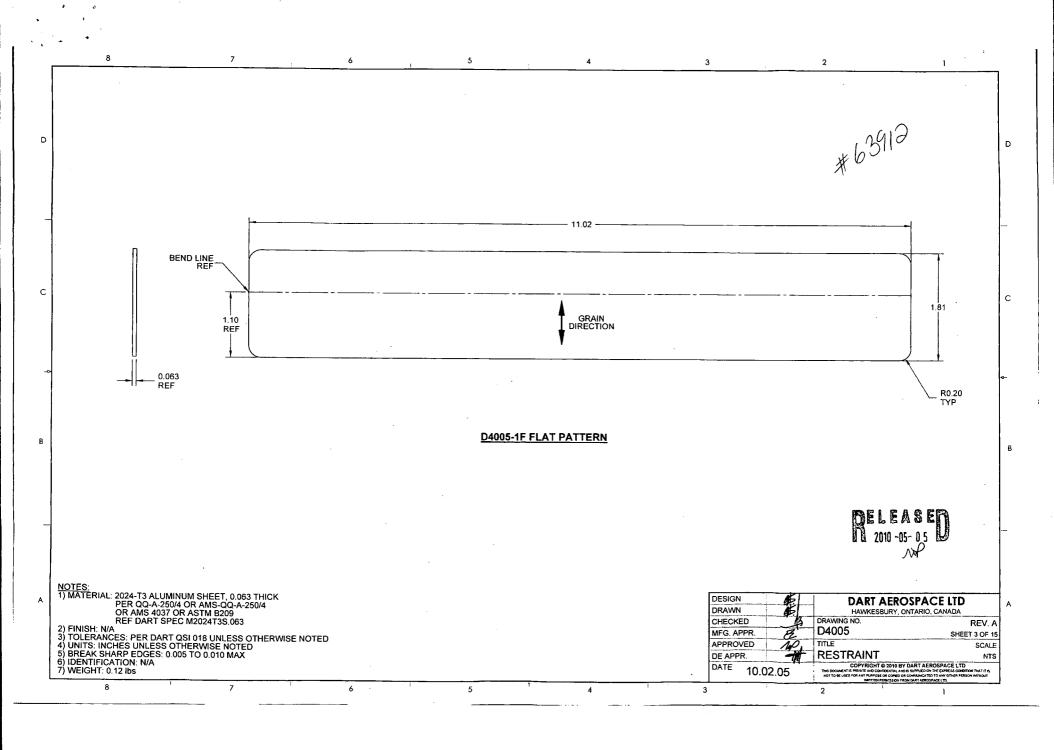
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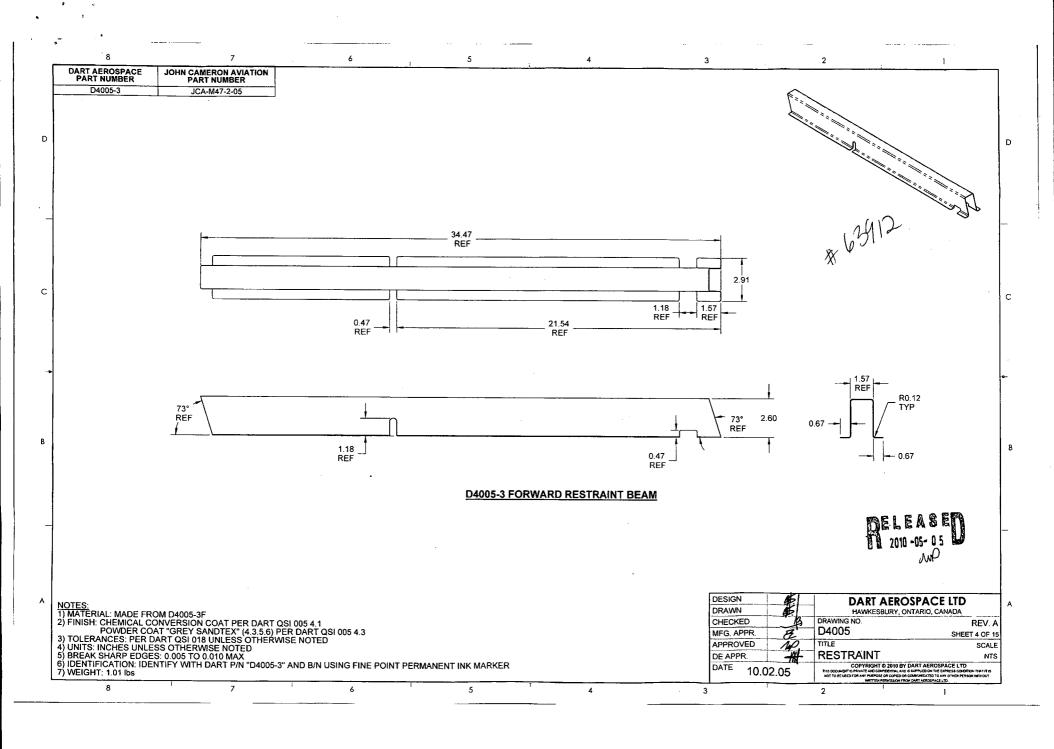
W/O:			WC	RK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	):	PAR #:	Fault Cate	gory:	_ NCR: Yes 1	No DQA:	Date:	
		esolution:						
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR)			
DATE	STEP	Description of NC	1	Corrective Action Section		Verification		Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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W/O:			V	ORK ORDER CHANGE	ES						
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						<u> </u>					
Part No	<u> </u>	PAR #:	Fault Ca	tegory:	NCR: Yes	s No I	DQA:	_ Date: _			
			Disposit	ion:	_ QA: N/C	Closed:	Closed: Date:				
NCR:		We	ORK OR	DER NON-CONFORMA	NCE (NC	R)					
DATE	STEP	Description of NC Corrective Action Section				Ve	rification	Approval	Approval		
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
Res		esolution:	Disposition	l:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	<b>(</b> )			
DATE	STEP	Description of NC	<u> </u>	Corrective Action Section		Verific	cation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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W/O:			V	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	<b>4</b> :	Date: _	
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NCR:		V	ORK OR	DER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC	1	Corrective Action Section		Verific		Approval	Approval
J/(12	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	on C	Chief Eng	QC Inspector

\*63912 - 21.52 -R0.24 0.78 R0.12 1.18 -REF 1.08 TYP GRAIN --- 0.78 BEND LINES 3.16 TYP 1.79 0.040 TYP 0.66 REF

**D4005-3F FLAT PATTERN** 

D

NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.040

D

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.01 lbs

DESIGN	<b>0</b> 22	DART AERO	SPACE LTD
DRAWN	<b>3</b> 51	HAWKESBURY, ON	TARIO, CANADA
CHECKED	B	DRAWING NO.	REV. A
MFG, APPR.	E	D4005	SHEET 5 OF 15
APPROVED	140	TITLE	SCALE
DE APPR.	-#	RESTRAINT	NTS
DATE 10.0	2.05	COPYRIGHT © 2010 BY D THIS DOCUMENT IS PROVIDE AND COMPRISH AND CO	SUPPLIED ON THE EXPRESS CONDITION THAT IT IS

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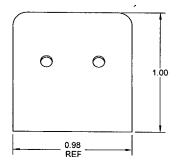
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DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
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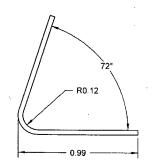
DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4005-5 JCA-M47-2-06

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NOTES:
1) MATERIAL: MADE FROM D4005-5F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-5" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.01 lbs

6

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D4005 MFG. APPR. SHEET 6 OF 15 TITLE APPROVED SCALE RESTRAINT DE APPR. NTS DATE 10.02.05 COPYRIGHT © 2010 BY DART AEROSPACE LTD

PES OCCURENT IS PRINTE AND COMPRIBING AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT AS

NOT TO BE USED FOR ANY PAIRODS OR COMPLICATION TO NAY OTHER PERSON WITHOUT

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**D4005-5 ANGLE** 

5

W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Ca	tegory:	NC	R: Yes	No <b>DQ</b>	A:	_ Date: _	
	Res	solution:	Disposit	ion:	QA	: N/C Cld	sed:		Date:	
NCR:		\	WORK OR	DER NON-CONFO	PRMANCE	(NCR	)			
DATE	STEP	Description of NC		Corrective Action Section B			Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	otion	Sign & Date	Secti		Chief Eng	QC Inspector
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3 2 D R0.12 TYP GRAIN DIRECTION BEND LINE REF С 1.93 Ø0.098 2 PL 0.96 REF 0.43 0.040 0.43 - 0.28 REF - 0.98 -**D4005-5F FLAT PATTERN** NOTES: 1) MATÉRIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.040 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A 2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.01 lbs D4005 MFG. APPR SHEET 7 OF 15 APPROVED TITLE RESTRAINT DE APPR.

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THE DOCUMENT'S PRIVATE AND CONFIDENCE OF THE CONFIRMS CONFIDENCE
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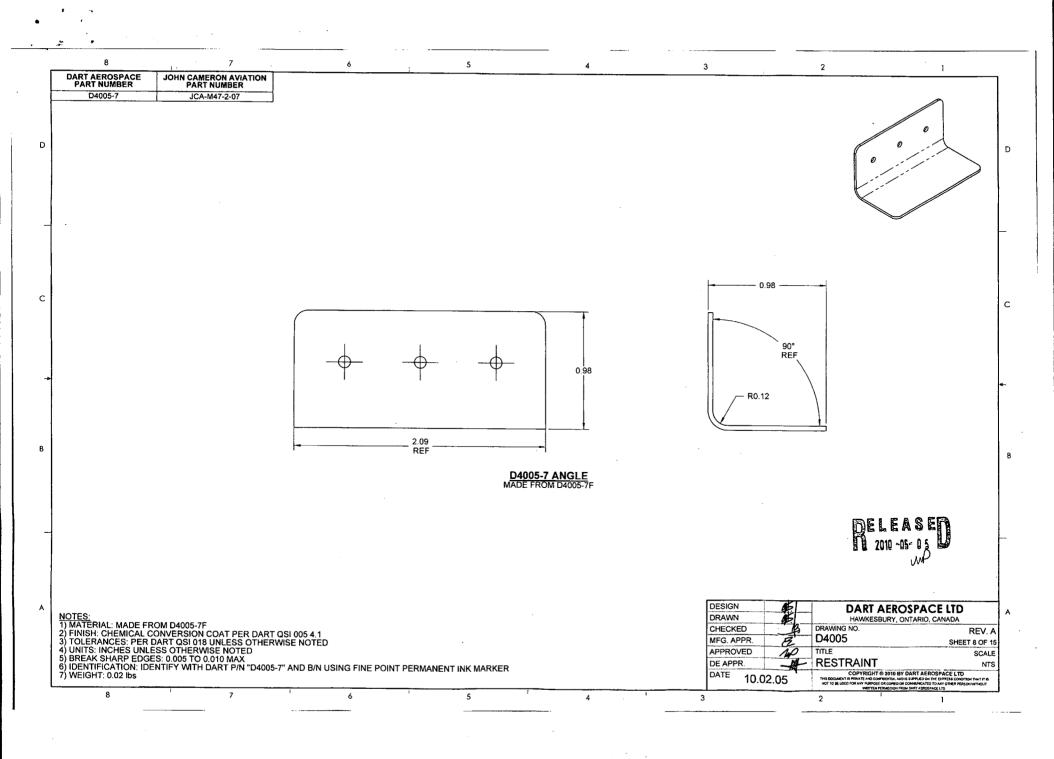
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W/O:			V	VORK ORDER CHANGE	S			
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							Frod Wigi	
Part No	·	PAR #:	_ Fault Ca	tegory:	NCR: Yes	lo DQA:	Date: _	
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NCR:		V	ORK OR	DER NON-CONFORMA	NCE (NCR)	)		
D.4.T.F.	0===	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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W/O:			W	ES				
DATE	STEP	PRO	PROCEDURE CHANGE				Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	·	PAR #:	Fault Cat	egory:	NCR: Yes	No <b>DQA:</b>	Date: _	<del></del>
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DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

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8 Đ D 2.09 GRAIN DIRECTION BEND LINE REF 1.87 Ø0.098 3 PL 0.93 REE 0.43 R0.12 TYP 0.63 0.040 TYP REF TYP **D4005-7F FLAT PATTERN** 

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NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.040 REF DART SPEC M2024T3S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

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DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4005 MFG. APPR SHEET 9 OF 15 APPROVED TITLE SCALE RESTRAINT DE APPR NTS DATE 10.02.05

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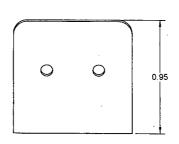
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Part No	:	PAR #:	_ Fault Cat	egory: N	CR: Yes	No <b>DQ</b>	<b>A</b> :	Date:	
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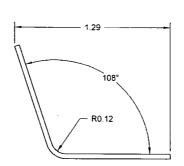
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DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4005-9 JCA-M47-2-08

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**D4005-9 ANGLE** 

NOTES:
1) MATERIAL: MADE FROM D4005-9F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-9" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.01 lbs

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DESIGN	<b>A</b>	DART AEROSPACE LTD				
DRAWN	<b>3</b>	HAWKESBURY, ONTARIO, CANADA				
CHECKED	B	DRAWING NO.	REV. A			
MFG. APPR.		D4005	SHEET 10 OF 15			
APPROVED	10.	TITLE .	SCALE			
DE APPR.	_#	RESTRAINT	NTS			
DATE 10.0	2.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD  THE DOCUMENT A PRIVATE AND COMPONITION AND AS IMPRILED ON THE EXPRESS COMMON THAT IT IS NOT TO BE USED FOR AN PURPOSE OF COMPECO A COMMUNICATED TO ANY OTHER PERSON WITHOUT				

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Part No		PAR #:	Fault Cat	egory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _				
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D D R0.12 0.98 TYP GRAIN DIRECTION BEND LINE С REF С 1.91 0.96 REF 0.43 0.040 REF Ø0.098 0.28 - 0.43 -2 PL **D4005-9F FLAT PATTERN** DELEASEP 1 2010 -05- 0 5 NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.040 DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A REF DART SPEC M2024T3S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs D4005 MFG. APPR. **SHEET 11 OF 15** TITLE APPROVED SCALE RESTRAINT DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD

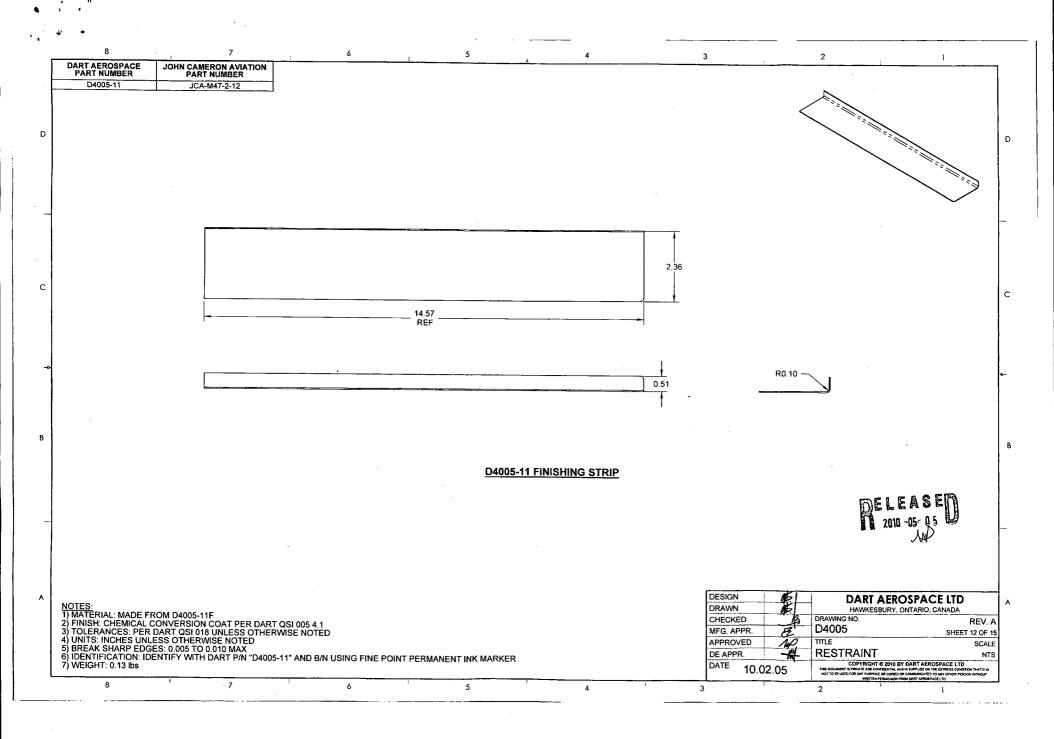
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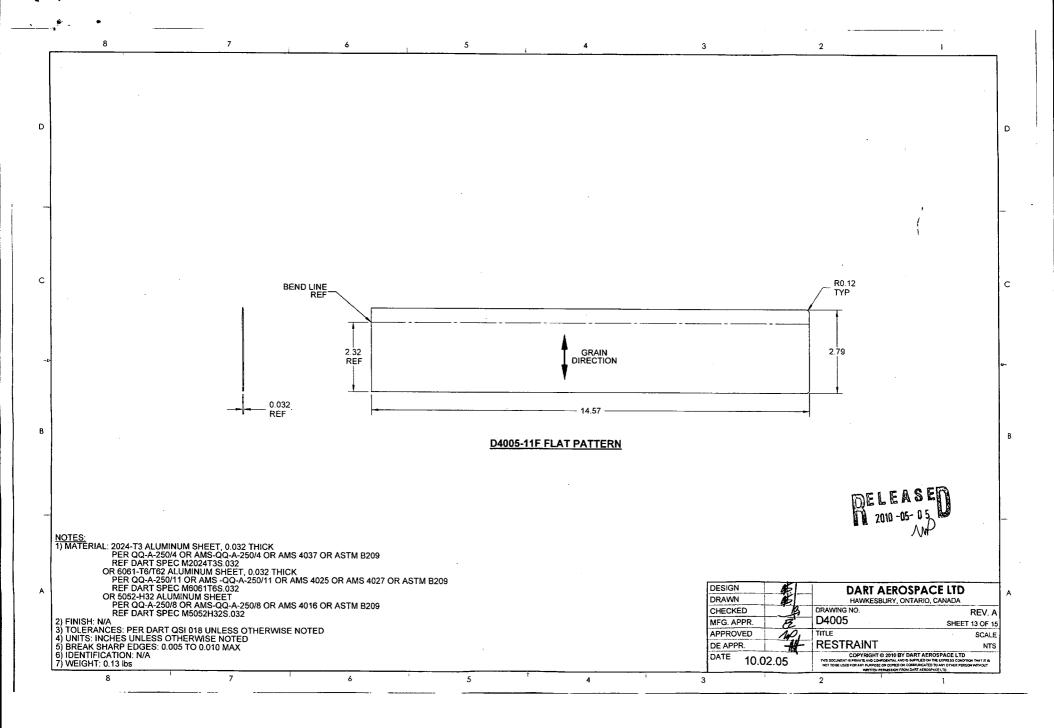
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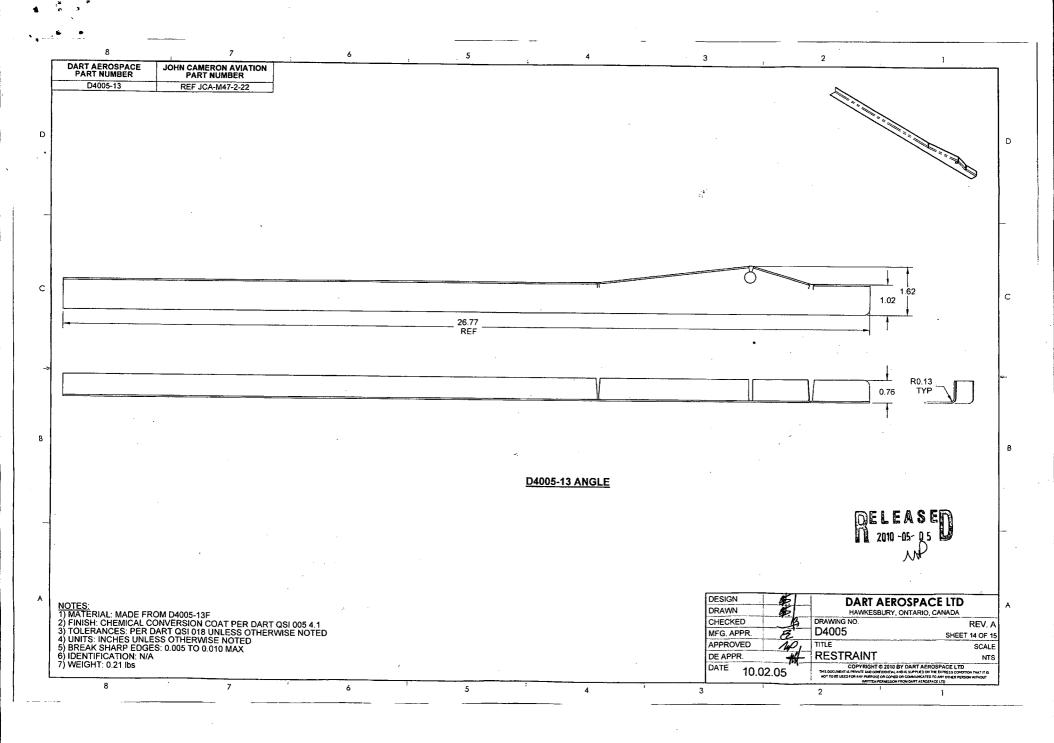
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Dart Aerospace Ltd
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NCR:			WORK ORE	DER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC		Corrective Action Section		Verific		Approval	Approval
	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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DATE	STEP	Description of NC	Initial	Corrective Action Section		gn &	Verific		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

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BEND LINE BEND LINE 9.08 R0.38 TYP BEND LINE BEND LINE REF 0.7Ó REF, TYP - 1.88 --- 1.87 GRAIN DIRECTION 2.22 2.26 1.67 0.97 1 25 REF Ø0:375 -0.040 R0.20 REF 26.77 -

#### **D4005-13F FLAT PATTERN**



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NOTES: 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.040

REF DART SPEC M6061T6S.040

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.21 lbs

DESIGN	_ 65	DART AEROSPACE LTD				
DRAWN	45	HAWKESBURY, ONT				
CHECKED	B	DRAWING NO.	REV. A			
MFG. APPR.	E	D4005	SHEET 15 OF 15			
APPROVED	10,	TITLE	SCALE			
DE APPR.	-#	RESTRAINT	NTS			
DATE 10.0	2.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT: SPRONTE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONFIDENT THIS NOT TO BE USED FOR ANY PURPOSE OF COPED OR COMMENCENTED TO ANY OTHER PERSON WITHOUT				

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NOTE: Date & initial all entries

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